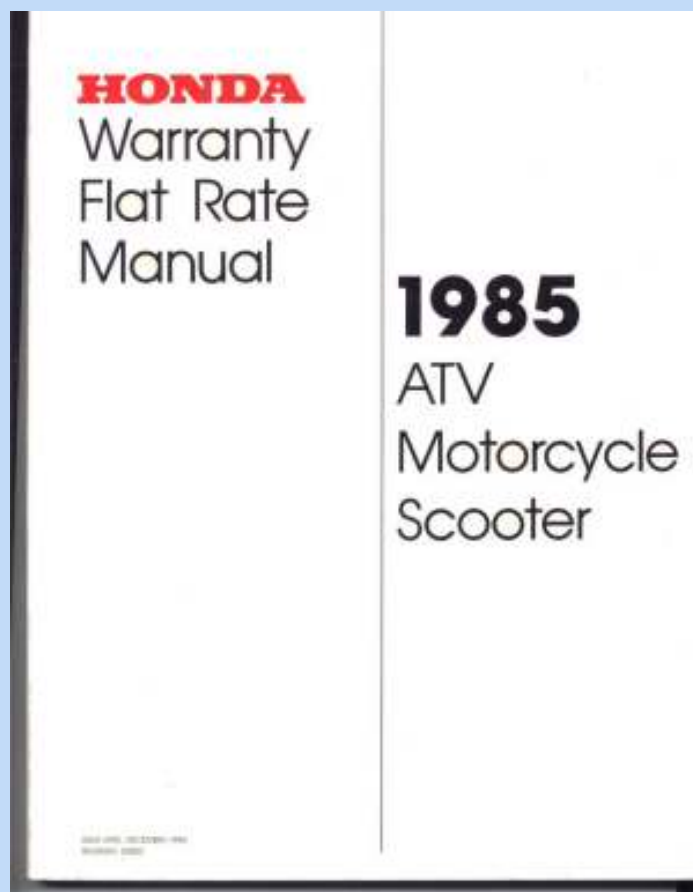


Motorcycle Flat Rate Times



Every repair job takes time. How much time a repair takes is known as the Flat Rate Time for that job. How do they come up with that time? The factory time studies the different motorcycles models on the assembly lines. They time each procedure a number of times and get an average time for each procedure. A procedure might be cut a valve seat, or assemble the valve and springs into the cylinder head or assemble a clutch. Each repair procedure is then assigned a number.

Factories like to time study every little thing for a reason. When a bike under warranty breaks the factory wants to fix it the cheapest way possible. They require the dealer who fixes the bike to put the number of each repair procedure of each repair on the request form for payment. The factory totals up all the repairs, multiplies that number by the agreed on shop rate and pays the dealer accordingly.

The shop rate is the amount per hour that the shop charges per hour of labor. Most shops post it in the service area or you can just ask them what it is.

Repair shops often use these flat rates to figure out how much is a fair price to charge for each repair. This sounds good and all until you consider one thing. Factories want to loose as little money as possible. Warranty work losses them money. So what is a factory to do? Simple, make the repair procedure go as fast as possible while still making it seem fair. So how do they do this?

I once worked for a company repairing Natural Gas Meters. While I was there I watched them create a time study for gas meter repair. They basically took the fastest repair man in the shop, gave him new meter bodies and parts and timed him putting the meters together as fast as he could go. It was ready, set, go.... work, work, work, one meter done. Work, work, work, two meters done. Work, work, work, three meters done. Stop and rest. Time it again. Take the best time and that is how long it should take for that procedure.

That is how the motorcycle factories do it too. Time a man who has spent his entire adult life putting a piston into a cylinder. Give him all new parts and time him going as fast as he can go. That will guarantee you get a really fast repair time. Do the factories really do this? Perhaps I might be exaggerating a bit but not by much.

So what does this have to do with us? Most shops use some sort of time studies to figure out what to charge their customers. In a way this is good and in another way it is bad. If you are a slow, precise mechanic (Also known as Me) the time studies give you a fair price to charge and allow you to spend as much time as is needed to complete the repair. That is good. Trouble is the time studies are not always accurate. Sometimes the studies do repair at warp speed. That is bad because it does not allow enough time to realistically complete the repair.

Rusted bolts. Stripped screws. Dirty engines. Old rusty engines. These things make the job hard and time consuming. Sometimes engines just do not want to come apart. You have to [worry](#) and [piddle](#) with them to get them apart without breaking good, hard to find, parts.

So, in reality, the time study a factory gives for repair is more like a suggestion than a rule. What we really want is to know is the time it takes a trained mechanic, working at a reasonable speed, on a clean and well cared for motorcycle, to do a repair. If the motorcycle is rusted, dirty and poorly maintained the time it takes to repair it will be longer.

So let us put some numbers to this.

1999

Shop Rate 2

1

Shop Rate 2

1

Shop Rate 3

100

Shop Rate 5

10

Shop Rate 5

Shop Rate 6

Shop Rate	Hour	1/2	3/4	1	1 1/4	1 1/2	1 3/4	2	2 1/4	2 1/2	2 3/4	3	3 1/4	3 1/2	3 3/4	4	4 1/4	4 1/2	4 3/4	5	5 1/4	5 1/2	5 3/4	6	6 1/4	6 1/2	6 3/4	7	7 1/4	7 1/2	7 3/4	8	8 1/4	8 1/2	8 3/4	9	9 1/4	9 1/2	9 3/4	10	10 1/4	10 1/2	10 3/4	11	11 1/4	11 1/2	11 3/4	12	12 1/4	12 1/2	12 3/4	13	13 1/4	13 1/2	13 3/4	14	14 1/4	14 1/2	14 3/4	15	15 1/4	15 1/2	15 3/4	16	16 1/4	16 1/2	16 3/4	17	17 1/4	17 1/2	17 3/4	18	18 1/4	18 1/2	18 3/4	19	19 1/4	19 1/2	19 3/4	20	20 1/4	20 1/2	20 3/4	21	21 1/4	21 1/2	21 3/4	22	22 1/4	22 1/2	22 3/4	23	23 1/4	23 1/2	23 3/4	24	24 1/4	24 1/2	24 3/4	25	25 1/4	25 1/2	25 3/4	26	26 1/4	26 1/2	26 3/4	27	27 1/4	27 1/2	27 3/4	28	28 1/4	28 1/2	28 3/4	29	29 1/4	29 1/2	29 3/4	30	30 1/4	30 1/2	30 3/4	31	31 1/4	31 1/2	31 3/4	32	32 1/4	32 1/2	32 3/4	33	33 1/4	33 1/2	33 3/4	34	34 1/4	34 1/2	34 3/4	35	35 1/4	35 1/2	35 3/4	36	36 1/4	36 1/2	36 3/4	37	37 1/4	37 1/2	37 3/4	38	38 1/4	38 1/2	38 3/4	39	39 1/4	39 1/2	39 3/4	40	40 1/4	40 1/2	40 3/4	41	41 1/4	41 1/2	41 3/4	42	42 1/4	42 1/2	42 3/4	43	43 1/4	43 1/2	43 3/4	44	44 1/4	44 1/2	44 3/4	45	45 1/4	45 1/2	45 3/4	46	46 1/4	46 1/2	46 3/4	47	47 1/4	47 1/2	47 3/4	48	48 1/4	48 1/2	48 3/4	49	49 1/4	49 1/2	49 3/4	50	50 1/4	50 1/2	50 3/4	51	51 1/4	51 1/2	51 3/4	52	52 1/4	52 1/2	52 3/4	53	53 1/4	53 1/2	53 3/4	54	54 1/4	54 1/2	54 3/4	55	55 1/4	55 1/2	55 3/4	56	56 1/4	56 1/2	56 3/4	57	57 1/4	57 1/2	57 3/4	58	58 1/4	58 1/2	58 3/4	59	59 1/4	59 1/2	59 3/4	60	60 1/4	60 1/2	60 3/4	61	61 1/4	61 1/2	61 3/4	62	62 1/4	62 1/2	62 3/4	63	63 1/4	63 1/2	63 3/4	64	64 1/4	64 1/2	64 3/4	65	65 1/4	65 1/2	65 3/4	66	66 1/4	66 1/2	66 3/4	67	67 1/4	67 1/2	67 3/4	68	68 1/4	68 1/2	68 3/4	69	69 1/4	69 1/2	69 3/4	70	70 1/4	70 1/2	70 3/4	71	71 1/4	71 1/2	71 3/4	72	72 1/4	72 1/2	72 3/4	73	73 1/4	73 1/2	73 3/4	74	74 1/4	74 1/2	74 3/4	75	75 1/4	75 1/2	75 3/4	76	76 1/4	76 1/2	76 3/4	77	77 1/4	77 1/2	77 3/4	78	78 1/4	78 1/2	78 3/4	79	79 1/4	79 1/2	79 3/4	80	80 1/4	80 1/2	80 3/4	81	81 1/4	81 1/2	81 3/4	82	82 1/4	82 1/2	82 3/4	83	83 1/4	83 1/2	83 3/4	84	84 1/4	84 1/2	84 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1/4	158 1/2	158 3/4	159	159 1/4	159 1/2	159 3/4	160	160 1/4	160 1/2	160 3/4	161	161 1/4	161 1/2	161 3/4	162	162 1/4	162 1/2	162 3/4	163	163 1/4	163 1/2	163 3/4	164	164 1/4	164 1/2	164 3/4	165	165 1/4	165 1/2	165 3/4	166	166 1/4	166 1/2	166 3/4	167	167 1/4	167 1/2	167 3/4	168	168 1/4	168 1/2	168 3/4	169	169 1/4	169 1/2	169 3/4	170	170 1/4	170 1/2	170 3/4	171	171 1/4	171 1/2	171 3/4	172	172 1/4	172 1/2	172 3/4	173	173 1/4	173 1/2	173 3/4	174	174 1/4	174 1/2	174 3/4	175	175 1/4	175 1/2	175 3/4	176	176 1/4	176 1/2	176 3/4	177	177 1/4	177 1/2	177 3/4	178	178 1/4	178 1/2	178 3/4	179	179 1/4	179 1/2	179 3/4	180	180 1/4	180 1/2	180 3/4	181	181 1/4	181 1/2	181 3/4	182	182 1/4	182 1/2	182 3/4	183	183 1/4	183 1/2	183 3/4	184	184 1/4	184 1/2	184 3/4	185	185 1/4	185 1/2	185 3/4	186	186 1/4	186 1/2	186 3/4	187	187 1/4	187 1/2	187 3/4	188	188 1/4	188 1/2	188 3/4	189	189 1/4	189 1/2	189 3/4	190	190 1/4	190 1/2	190 3/4	191	191 1/4	191 1/2	191 3/4	192	192 1/4	192 1/2	192 3/4	193	193 1/4	193 1/2	193 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1/4	265 1/2	265 3/4	266	266 1/4	266 1/2	266 3/4	267	267 1/4	267 1/2	267 3/4	268	268 1/4	268 1/2	268 3/4	269	269 1/4	269 1/2	269 3/4	270	270 1/4	270 1/2	270 3/4	271	271 1/4	271 1/2	271 3/4	272	272 1/4	272 1/2	272 3/4	273	273 1/4	273 1/2	273 3/4	274	274 1/4	274 1/2	274 3/4	275	275 1/4	275 1/2	275 3/4	276	276 1/4	276 1/2	276 3/4	277	277 1/4	277 1/2	277 3/4	278	278 1/4	278 1/2	278 3/4	279	279 1/4	279 1/2	279 3/4	280	280 1/4	280 1/2	280 3/4	281	281 1/4	281 1/2	281 3/4	282	282 1/4	282 1/2	282 3/4	283	283 1/4	283 1/2	283 3/4	284	284 1/4	284 1/2	284 3/4	285	285 1/4	285 1/2	285 3/4	286	286 1/4	286 1/2	286 3/4	287	287 1/4	287 1/2	287 3/4	288	288 1/4	288 1/2	288 3/4	289	289 1/4	289 1/2	289 3/4	290
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PRICE CONVERSION TABLE

Suggested Time (hrs.)	LABOR RATE PER HOUR						
	\$1.00	\$2.00	\$3.00	\$4.00	\$5.00	\$6.00	\$6.00
0.1	0.20	0.40	0.60	0.80	1.00	1.20	1.40
0.2	0.30	0.60	0.90	1.20	1.50	1.80	2.10
0.3	0.40	0.80	1.20	1.60	2.00	2.40	2.80
0.4	0.50	1.00	1.50	2.00	2.50	3.00	3.50
0.5	0.60	1.20	1.80	2.40	3.00	3.60	4.20
0.6	0.70	1.40	2.10	2.80	3.50	4.20	4.90
0.7	0.80	1.60	2.40	3.20	4.00	4.80	5.60
0.8	0.90	1.80	2.70	3.60	4.50	5.40	6.30
0.9	1.00	2.00	3.00	4.00	5.00	6.00	7.00
1.0	1.10	2.20	3.30	4.40	5.50	6.60	7.70
1.1	1.20	2.40	3.60	4.80	6.00	7.20	8.40
1.2	1.30	2.60	3.90	5.20	6.40	7.60	8.80
1.3	1.40	2.80	4.20	5.60	6.80	8.00	9.20
1.4	1.50	3.00	4.50	6.00	7.20	8.40	9.60
1.5	1.60	3.20	4.80	6.40	7.60	8.80	10.00
1.6	1.70	3.40	5.10	6.80	8.00	9.20	10.40
1.7	1.80	3.60	5.40	7.20	8.40	9.60	10.80
1.8	1.90	3.80	5.70	7.60	8.80	10.00	11.20
1.9	2.00	4.00	6.00	8.00	9.20	10.40	11.60
2.0	2.10	4.20	6.30	8.40	9.60	10.80	12.00
2.1	2.20	4.40	6.60	8.80	10.00	11.20	12.40
2.2	2.30	4.60	6.90	9.20	10.40	11.60	12.80
2.3	2.40	4.80	7.20	9.60	10.80	12.00	13.20
2.4	2.50	5.00	7.50	10.00	11.20	12.40	13.60
2.5	2.60	5.20	7.80	10.40	11.60	12.80	14.00
2.6	2.70	5.40	8.10	10.80	12.00	13.20	14.40
2.7	2.80	5.60	8.40	11.20	12.40	13.60	14.80
2.8	2.90	5.80	8.70	11.60	12.80	14.00	15.20
2.9	3.00	6.00	9.00	12.00	13.20	14.40	15.60
3.0	3.10	6.20	9.30	12.40	13.60	14.80	16.00
3.1	3.20	6.40	9.60	12.80	14.00	15.20	16.40
3.2	3.30	6.60	9.90	13.20	14.40	15.60	16.80
3.3	3.40	6.80	10.20	13.60	14.80	16.00	17.20
3.4	3.50	7.00	10.50	14.00	15.20	16.40	17.60
3.5	3.60	7.20	10.80	14.40	15.60	16.80	18.00
3.6	3.70	7.40	11.10	14.80	16.00	17.20	18.40
3.7	3.80	7.60	11.40	15.20	16.40	17.60	18.80
3.8	3.90	7.80	11.70	15.60	16.80	18.00	19.20
3.9	4.00	8.00	12.00	16.00	17.20	18.40	19.60
4.0	4.10	8.20	12.30	16.40	17.60	18.80	20.00
4.1	4.20	8.40	12.60	16.80	18.00	19.20	20.40
4.2	4.30	8.60	12.90	17.20	18.40	19.60	20.80
4.3	4.40	8.80	13.20	17.60	18.80	20.00	21.20
4.4	4.50	9.00	13.50	18.00	19.20	20.40	21.60
4.5	4.60	9.20	13.80	18.40	19.60	20.80	22.00
4.6	4.70	9.40	14.10	18.80	20.00	21.20	22.40
4.7	4.80	9.60	14.40	19.20	20.40	21.60	22.80
4.8	4.90	9.80	14.70	19.60	20.80	22.00	23.20
4.9	5.00	10.00	15.00	20.00	21.20	22.40	23.60
5.0	5.10	10.20	15.30	20.40	21.60	22.80	24.00
5.1	5.20	10.40	15.60	20.80	22.00	23.20	24.40
5.2	5.30	10.60	15.90	21.20	22.40	23.60	24.80
5.3	5.40	10.80	16.20	21.60	22.80	24.00	25.20
5.4	5.50	11.00	16.50	22.00	23.20	24.40	25.60
5.5	5.60	11.20	16.80	22.40	23.60	24.80	26.00
5.6	5.70	11.40	17.10	22.80	24.00	25.20	26.40
5.7	5.80	11.60	17.40	23.20	24.40	25.60	26.80
5.8	5.90	11.80	17.70	23.60	24.80	26.00	27.20
5.9	6.00	12.00	18.00	24.00	25.20	26.40	27.60
6.0	6.10	12.20	18.30	24.40	25.60	26.80	28.00
6.1	6.20	12.40	18.60	24.80	26.00	27.20	28.40
6.2	6.30	12.60	18.90	25.20	26.40	27.60	28.80
6.3	6.40	12.80	19.20	25.60	26.80	28.00	29.20
6.4	6.50	13.00	19.50	26.00	27.20	28.40	29.60
6.5	6.60	13.20	19.80	26.40	27.60	28.80	30.00
6.6	6.70	13.40	20.10	26.80	28.00	29.20	30.40
6.7	6.80	13.60	20.40	27.20	28.40	29.60	30.80
6.8	6.90	13.80	20.70	27.60	28.80	30.00	31.20
6.9	7.00	14.00	21.00	28.00	29.20	30.40	31.60
7.0	7.10	14.20	21.30	28.40	29.60	30.80	32.00
7.1	7.20	14.40	21.60	28.80	30.00	31.20	32.40
7.2	7.30	14.60	21.90	29.20	30.40	31.60	32.80
7.3	7.40	14.80	22.20	29.60	30.80	32.00	33.20
7.4	7.50	15.00	22.50	30.00	31.20	32.40	33.60
7.5	7.60	15.20	22.80	30.40	31.60	32.80	34.00
7.6	7.70	15.40	23.10	30.80	32.00	33.20	34.40
7.7	7.80	15.60	23.40	31.20	32.40	33.60	34.80
7.8	7.90	15.80	23.70	31.60	32.80	34.00	35.20
7.9	8.00	16.00	24.00	32.00	33.20	34.40	35.60
8.0	8.10	16.20	24.30	32.40	33.60	34.80	36.00
8.1	8.20	16.40	24.60	32.80	34.00	35.20	36.40
8.2	8.30	16.60	24.90	33.20	34.40	35.60	36.80
8.3	8.40	16.80	25.20	33.60	34.80	36.00	37.20
8.4	8.50	17.00	25.50	34.00	35.20	36.40	37.60
8.5	8.60	17.20	25.80	34.40	35.60	36.80	38.00
8.6	8.70	17.40	26.10	34.80	36.00	37.20	38.40
8.7	8.80	17.60	26.40	35.20	36.40	37.60	38.80
8.8	8.90	17.80	26.70	35.60	36.80	38.00	39.20
8.9	9.00	18.00	27.00	36.00	37.20	38.40	39.60
9.0	9.10	18.20	27.30	36.40	37.60	38.80	40.00
9.1	9.20	18.40	27.60	36.80	38.00	39.20	40.40
9.2	9.30	18.60	27.90	37.20	38.40	39.60	40.80
9.3	9.40	18.80	28.20	37.60	38.80	40.00	41.20
9.4	9.50	19.00	28.50	38.00	39.20	40.40	41.60
9.5	9.60	19.20	28.80	38.40	39.60	40.80	42.00
9.6	9.70	19.40	29.10	38.80	40.00	41.20	42.40
9.7	9.80	19.60	29.40	39.20	40.40	41.60	42.80
9.8	9.90	19.80	29.70	39.60	40.80	42.00	43.20
9.9	10.00	20.00	30.00	40.00	41.20	42.40	43.60
10.0	10.10	20.20	30.30	40.40	41.60	42.80	44.00
10.1	10.20	20.40	30.60	40.80	42.00	43.20	44.40
10.2	10.30	20.60	30.90	41.20	42.40	43.60	44.80
10.3	10.40	20.80	31.20	41.60	42.80	44.00	45.20
10.4	10.50	21.00	31.50	42.00	43.20	44.40	45.60
10.5	10.60	21.20	31.80	42.40	43.60	44.80	46.00
10.6	10.70	21.40	32.10	42.80	44.00	45.20	46.40
10.7	10.80	21.60	32.40	43.20	44.40	45.60	46.80
10.8	10.90	21.80	32.70	43.60	44.80	46.00	47.20
10.9	11.00	22.00	33.00	44.00	45.20	46.40	47.60
11.0	11.10	22.20	33.30	44.40	45.60	46.80	48.00
11.1	11.20	22.40	33.60	44.80	46.00	47.20	48.40
11.2	11.30	22.60	33.90	45.20	46.40	47.60	48.80
11.3	11.40	22.80	34.20	45.60	46.80	48.00	49.20
11.4	11.50	23.00	34.50	46.00	47.20	48.40	49.60
11.5	11.60	23.20	34.80	46.40	47.60	48.80	50.00
11.6	11.70	23.40	35.10	46.80	48.00	49.20	50.40
11.7	11.80	23.60	35.40	47.20	48.40	49.60	50.80
11.8	11.90	23.80	35.70	47.60	48.80	50.00	51.20
11.9	12.00	24.00	36.00	48.00	49.20	50.40	51.60
12.0	12.10	24.20	36.30	48.40	49.60	50.80	52.00
12.1	12.20	24.40	36.60	48.80	50.00	51.20	52.40
12.2	12.30	24.60	36.90	49.20	50.40	51.60	52.80
12.3	12.40	24.80	37.20	49.60	50.80	52.00	53.20
12.4	12.50	25.00	37.50	50.00	51.20	52.40	53.60
12.5	12.60	25.20	37.80	50.40	51.60	52.80	54.00
12.6	12.70	25.40	38.10	50.80	52.00	53.20	54.40
12.7	12.80	25.60	38.40	51.20	52.40	53.60	54.80
12.8	12.90	25.80	38.70	51.60	52.80	54.00	55.20
12.9	13.00	26.00	39.00	52.00	53.20	54.40	55.60
13.0	13.10	26.20	39.30	52.40	53.60	54.80	56.00
13.1	13.20	26.40	39.60	52.80	54.00	55.20	56.40
13.2	13.30	26.60	39.90	53.20	54.40	55.60	56.80
13.3	13.40	26.80	40.20	53.60	54.80	56.00	57.20
13.4	13.50	27.00	40.50	54.00	55.20	56.40	57.60
13.5	13.60	27.20	40.80	54.40	55.60	56.80	58.00
13.6	13.70	27.40	41.10	54.80	56.00	57.20	58.40
13.7	13.80	27.60	41.40	55.20	56.40	57.60	58.80
13.8	13.90	27.80	41.70	55.60	56.80	58.00	59.20
13.9	14.00	28.00	42.00	56.00	57.20	58.40	59.60
14.0	14.10	28.20	42.30	56.40	57.60	58.80	60.00
14.1	14.20	28.40	42.60	56.80	58.00	59.20	60.40
14.2	14.30	28.60	42.90	57.20	58.40	59.60	60.80
14.3	14.40	28.80	43.20	57.60	58.80	60.00	61.20
14.4	14.50	29.00	43.50	58.00	59.20	60.40	61.60
14.5	14.60	29.20	43.80	58.40	59.60	60.80	62.00
14.6	14.70	29.40	44.10	58.80	60.00	61.20	62.40
14.7	14.80	29.60	44.40	59.20	60.40	61.60	62.80
14.8	14.90	29.80	44.70	59.60	60.80	62.00	63.20
14.9	15.00	30.00	45				

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
110100		ENGINE REMOVE AND REPLACE	0.9	0.9	0.9	2.1	2.1	2.1	2.2
110105		CRANKCASE SET	—	—	—	—	—	6.7	7.0
110110		CRANKCASE GASKET	2.6	2.7	2.7	5.5	5.5	5.5	5.8
110115		LEFT CRANKCASE	2.9	3.6	3.6	6.5	6.5	6.5	6.5
110120		RIGHT CRANKCASE	2.8	3.0	3.0	5.7	5.7	5.7	6.1
110125		CRANKSHAFT, MAIN BEARING, MAIN BEARING HOLDERS (INCLUDES TIMING SPROCKET)	2.6	3.1	3.1	6.4	6.4	6.4	6.1
110135		BALANCER ASSEMBLY, BEARING, SHAFT, CHAIN OR GUIDE	—	—	—	5.8	5.8	5.8	6.0
110140		CAM CHAIN	1.3	2.7	2.7	2.7	2.7	2.7	4.2
110130		CRANKSHAFT OIL SEAL	0.4	0.5	0.5	0.7	0.7	0.7	0.8
110155		LEFT CRANKCASE COVER OR GASKET	0.1	0.1	0.1	0.8	0.8	0.7	0.7
110160		RIGHT CRANKCASE COVER OR GASKET	0.5	0.7	0.7	0.8	0.8	0.8	0.8
111100		CYLINDER, CYLINDER BASE GASKET	1.0	1.4	1.4	2.7	2.7	2.7	3.4
111103		PISTON, RINGS, PIN OR BEARING (ONE)	1.1	1.5	1.5	2.8	2.8	2.8	3.5
111106		CYLINDER HEAD	1.2	1.5	1.5	2.7	2.7	2.7	3.7
111109		INTAKE OR EXHAUST VALVE GUIDE (ONE)	1.3	1.6	1.6	2.6	2.6	2.6	3.6
	G	EACH ADDITIONAL	0.4	0.4	0.4	0.4	0.4	0.4	0.4
111112		VALVE, VALVE SPRING OR SEAL (ONE)	1.0	1.3	1.3	2.3	2.3	2.3	3.4

111112	G	VALVE VALVE SPRING OR SEAL (ONE) EACH ADDITIONAL	1.0 0.1	1.3 0.1	1.3 0.1	2.3 0.1	2.3 0.1	2.3 0.1	3.4 0.1
111115		CYLINDER HEAD GASKET	0.9	1.2	1.2	2.2	2.2	2.2	3.2
111118		CAM SHAFT(S)	0.6	0.7	0.7	1.7	1.7	1.7	2.9
111121		CAM SHAFT SPROCKET, BEARING, BUSHING OR HOLDER	—	0.9	0.9	1.8	1.8	1.9	2.9
111130		CAM CHAIN TENSIONER	—	1.6	1.6	3.2	3.2	2.8	3.9
111133		CAM CHAIN TENSIONER LIFTER, ADJUSTER OR BRACKET ASSEMBLY/PUSHROD ASSEMBLY	0.2	—	—	—	—	2.2	3.4
111136		CAM CHAIN TENSIONER SPRING	0.2	1.6	1.6	3.2	3.2	2.2	3.4
111139		CAM CHAIN TENSIONER GUIDE	—	1.4	1.4	2.2	2.2	2.2	3.2
111148		CAM CHAIN TENSIONER ROLLER(S)	1.0	—	—	—	—	—	—
111151		CAM CHAIN TENSIONER ARM	1.3	—	—	—	—	—	—

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
111160	G	ROCKER ARM SUB ROCKER ARM SHAFT OR SIDE SPRING (ONE) EACH ADDITIONAL	0.9 0.1	0.6 0.1	0.6 0.1	1.6 0.1	1.6 0.1	1.6 0.1	2.7 0.1
111166		DECOMPRESSION CAM, LEVER, SEAL OR SPRING	—	—	—	1.6	1.6	1.7	2.7
111172		CYLINDER HEAD COVER, GASKET MATING SURFACE OR REED VALVE RESEALING	0.2	0.2	0.2	2.1	2.1	2.1	3.0
111175		TAPPET ADJUSTING COVER OR PACKING	0.1	0.1	0.1	0.1	0.1	0.1	0.1
112100		KICK STARTER SHAFT, IDLE GEAR, RATCHET OR RETURN SPRING	2.6	2.9	2.9	1.2	1.2	1.2	1.2
112105		KICK STARTER SHAFT SEAL	0.5	0.2	0.2	0.4	0.4	0.6	0.6
113200		OIL PUMP REBUILD	0.7	0.9	0.9	1.2	1.2	1.3	1.3
113105		OIL PUMP ASSEMBLY	0.5	0.8	0.8	0.9	0.9	1.2	1.2
113130		OIL PIPE, O-RING OR GASKET (INTERNAL)	—	—	—	—	—	0.9	0.9
113120		OIL PUMP SHAFT, GEAR, SPROCKET OR CHAIN	—	0.7	0.7	1.0	1.0	0.7	0.7
113125		OIL STRAINER SCREEN	0.5	0.6	0.6	0.8	0.8	0.7	0.7
113135		OIL PIPE, O-RING OR GASKET (EXTERNAL)	—	—	—	0.2	0.2	0.2	0.2
113140		OIL COOLER, HOSES OR O-RING	—	—	—	—	—	0.4	0.4

5-5

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
210200		TRANSMISSION REBUILD (INCLUDES CROSS SHAFT SET)	2.8	3.4	3.4	6.4	6.4	6.4	6.4
210120		SHIFT SHAFT OR RETURN SPRING	0.7	0.9	0.9	5.6	5.6	5.7	5.9
210115		TRANSMISSION SHIFT LINKAGE STOPPER OR SPRING	0.6	0.7	0.7	5.6	5.6	1.2	1.2
210130		SHIFT SHAFT SEAL	0.4	0.2	0.2	0.2	0.2	0.2	0.2
211100		PRIMARY DRIVEN GEAR, FACE OR PULLEY	0.7	1.3	1.3	1.0	1.0	1.0	1.0
211105		PRIMARY DRIVE GEAR, FACE OR PULLEY	0.5	0.5	0.5	1.0	1.0	1.0	1.3
212200		CLUTCH REBUILD	0.7	1.3	1.3	1.0	1.0	1.0	1.0
212110		CLUTCH ARM OR SEAL	—	0.7	0.7	—	0.7	0.7	0.7
213105		OUTPUT SHAFT SEAL	0.4	0.4	0.4	5.4	5.4	0.5	0.5
213135		DRIVE SPROCKET OR CHAIN	0.4	0.4	0.4	0.4	0.4	0.4	0.4

5-6

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
310100		FUEL TANK ASSEMBLY	0.4	0.4	0.4	0.4	0.4	0.4	0.4
310110		PETCOCK	0.2	0.2	0.2	0.2	0.2	0.2	0.2
311200	G	CARBURETOR REBUILD (ONE) EACH ADDITIONAL	0.4 —	0.6 —	0.6 —	1.2 0.2	1.2 0.2	0.9 —	1.2 0.2
311105		CARBURETOR ASSEMBLY	0.2	0.4	0.4	0.9	0.9	0.5	0.9
311110		CARBURETOR INSULATOR OR MANIFOLD (ONE)	0.2	0.2	0.2	0.7	0.7	0.7	1.0
312100		AIR CLEANER CASE	0.2	0.4	0.4	0.6	0.6	0.5	0.6
312105		AIR CLEANER ELEMENT	0.1	0.2	0.2	0.2	0.2	0.2	0.2
313100	G	EXHAUST FLANGE STUD (ONE) EACH ADDITIONAL	0.2 0.1	0.4 0.1	0.4 0.1	0.4 0.1	0.4 0.1	0.4 0.1	0.4 0.1
313105		EXHAUST ASSEMBLY	0.4	0.2	0.2	0.5	0.5	0.4	0.4
313110		EXHAUST HEADER PIPE	—	—	—	0.2	0.2	0.2	0.2
313120		EXHAUST MUFFLER (ONE)	—	—	—	0.2	0.2	0.2	0.2
313125		EXHAUST HEAT SHIELD (ONE)	0.1	0.1	0.1	0.1	0.1	0.1	0.1

5-7

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
410100		FRAME	2.1	2.6	2.6	5.5	5.5	5.5	5.5
410135		SKID PLATE	—	0.1	0.1	0.1	0.1	0.2	0.2
410140		FOOT PEG BRACKET	0.4	0.5	0.5	0.1	0.1	0.2	0.2
410145		FOOT PEG	0.1	0.1	0.1	0.1	0.1	0.1	0.1
410180		SIDE STAND	0.1	0.2	0.2	0.2	0.2	0.2	0.2
410190		TOOL BOX OR BAG	—	—	—	0.2	0.2	0.2	0.2
410195		DRIVE CHAIN CASE, SLIPPERS OR BELT GUARD	—	0.2	0.2	0.2	0.2	0.2	0.2
413100		FRONT FENDER OR STAY (ONE)	0.1	0.1	0.1	0.2	0.2	0.2	0.2
413105		REAR FENDER A	0.2	0.2	0.2	0.4	0.4	0.4	0.4
413150		SEAT	0.1	0.1	0.1	0.1	0.1	0.1	0.1
413120		SIDE COVER(S)	0.1	0.1	0.1	0.1	0.1	0.1	0.1

5-8

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
510100		STEERING STEM OR SHAFT	0.6	0.8	0.8	1.2	1.2	1.2	1.2
510105		STEERING HEAD BEARINGS	0.7	0.9	0.9	1.5	1.5	1.5	1.5
510110		TOP FORK BRIDGE	0.2	0.4	0.4	0.4	0.4	0.4	0.4
511100	A	FRONT FORK ASSEMBLY LEFT	0.2	0.4	0.4	0.4	0.4	0.5	0.5
	B	RIGHT	0.2	0.4	0.4	0.4	0.4	0.5	0.5
511105	A	FRONT FORK PIPE, SLIDER OR SEAL LEFT	0.4	0.7	0.7	0.7	0.7	0.8	0.8
	B	RIGHT	0.4	0.7	0.7	0.7	0.7	0.8	0.8
511110	A	FRONT FORK SPRING OR RUBBER STOPPER LEFT	0.2	0.2	0.2	0.2	0.2	0.2	0.2
	B	RIGHT	0.2	0.2	0.2	0.2	0.2	0.2	0.2
511115	A	FRONT FORK CAP BOLT OR O-RING LEFT	—	0.1	0.1	0.1	0.1	0.2	0.1
	B	RIGHT	—	0.1	0.1	0.1	0.1	0.2	0.1
511120	A	FRONT FORK AIR VALVE OR O-RING LEFT	—	—	—	0.1	0.1	0.1	0.1
	B	RIGHT	—	—	—	0.1	0.1	0.1	0.1
512100		SWING ARM	0.6	0.6	0.6	1.5	1.5	1.5	1.5
512110		SWING ARM BEARINGS, BUSHINGS, OR COLLARS	0.7	0.8	0.8	2.0	2.0	2.0	2.0
512115	A	REAR SHOCK ABSORBER ASSEMBLY LEFT	—	0.2	0.2	0.9	0.9	0.9	0.9
	B	RIGHT	0.1	—	—	—	—	—	—
512120		REAR SHOCK ABSORBER DAMPER OR SPRING	0.1	—	—	—	—	—	—

512120		REAR SHOCK ABSORBER DAMPER	—	0.4	0.4	1.5	1.5	1.5	1.5
	A	OR SPRING	0.2	—	—	—	—	—	—
	B	LEFT RIGHT	0.2	—	—	—	—	—	—
512140		CUSHION ARM ASSEMBLY, BUSHINGS, COLLARS, OR PIVOT SEALS (TOP)	—	0.4	0.4	0.8	0.8	1.2	1.2
512145		CUSHION ARM ROD ASSEMBLY, BUSHINGS, COLLARS, OR PIVOT SEALS	—	0.4	0.4	0.4	0.4	0.5	0.5

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
611100		WIRE HARNESS (MAIN)	0.4	0.5	0.5	0.7	0.7	0.7	0.7
613100		GENERATOR ASSEMBLY OR STATOR	0.5	0.5	0.5	1.2	1.2	1.2	1.2
613105		ROTOR OR FLYWHEEL	0.2	0.2	0.2	0.7	0.7	0.7	0.7
613110		VOLTAGE REGULATOR, RECTIFIER, OR REGULATOR/RECTIFIER COMBINATION	—	—	—	0.2	0.2	0.2	0.2
614100		C.D.I. OR SPARK UNIT	—	—	—	0.4	0.4	0.4	0.4
614105		IGNITION COIL(S)	0.4	0.4	0.4	0.4	0.4	0.4	0.4
614110		PULSER COIL(S) OR PULSER GENERATOR(S)	—	—	—	0.8	0.8	0.8	0.8
614115		POINTS, CONDENSER, OR RESISTOR	0.5	0.4	0.4	—	—	—	—
614130		SPARK PLUG(S)	0.1	0.1	0.1	0.1	0.1	0.1	0.1
615120		ENGINE STOP SWITCH	0.1	0.1	0.1	0.2	0.2	0.2	0.2
616103		HEADLIGHT CASE	—	—	—	0.2	0.2	0.2	0.2
616115		HEADLIGHT ASSEMBLY(S)	—	—	—	0.2	0.2	0.2	0.2
616118		HEADLIGHT BULB(S)	—	—	—	0.1	0.1	0.1	0.1
616124		TAILLIGHT ASSEMBLY(S) OR LICENSE LIGHT ASSEMBLY	—	—	—	0.2	0.2	0.2	0.2
616127		TAILLIGHT OR LICENSE LIGHT BULB(S)	—	—	—	0.1	0.1	0.1	0.1

5-10

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
710100		FRONT WHEEL ASSEMBLY (EACH)	0.2	0.2	0.2	0.2	0.2	0.2	0.2
710103		FRONT HUB(S)	0.6	1.7	1.7	2.2	2.2	1.9	1.9
710106		FRONT RIM (SPOKED)	0.6	1.7	1.7	2.2	2.2	1.9	1.9
710115		FRONT WHEEL BEARINGS (EACH WHEEL)	0.4	0.6	0.6	0.6	0.6	0.5	0.5
710118		REAR WHEEL ASSEMBLY (EACH)	0.4	0.4	0.4	0.4	0.4	0.4	0.4
710121		REAR HUB(S)	0.6	1.9	1.9	2.4	2.4	2.2	2.0
710124		REAR RIM (SPOKED)	0.6	1.9	1.9	2.4	2.4	2.2	2.0
710139		FRONT TIRE, TUBE OR VALVE STEM (EACH)	0.5	0.5	0.5	0.5	0.5	0.6	0.6
710142		REAR TIRE, TUBE OR VALVE STEM (EACH)	0.6	0.6	0.6	0.7	0.7	0.7	0.7
710145		SPEEDOMETER GEARBOX OR SEAL	—	—	—	0.2	0.2	0.2	0.2
710151		FRONT AXLE	0.1	0.2	0.2	0.2	0.2	0.2	0.2
710154		REAR SPROCKET OR SPROCKET FLANGE	0.4	0.4	0.4	0.5	0.5	0.5	0.5
710160		REAR AXLE	0.2	0.2	0.2	0.2	0.2	0.2	0.2
711100		FRONT BRAKE PANEL AND/OR CAM	0.2	0.4	0.4	0.4	—	—	—
711115		FRONT BRAKE SHOES OR PADS (ONE SET OR ONE WHEEL)	0.2	0.4	0.4	0.4	0.2	0.2	0.2
711120		FRONT DISC (ONE)	—	—	—	—	0.4	0.4	0.4
711225		FRONT CALIPER REBUILD (ONE)	—	—	—	—	0.9	0.9	0.9
711120		FRONT CALIPER ASSEMBLY (ONE)	—	—	—	—	0.6	0.6	0.6

711130		FRONT CALIPER ASSEMBLY (ONE)	—	—	—	—	0.6	0.6	0.6
711135		REAR BRAKE PANEL OR DRUM AND/OR CAM	0.4	0.5	0.5	0.5	0.5	0.5	0.5
711140		REAR BRAKE SHOES OR PADS	0.4	0.5	0.5	0.5	0.5	0.4	0.4
711165		REAR STOPPER ARM	—	0.2	0.2	—	—	—	—
712200		FRONT BRAKE MASTER CYLINDER REBUILD	—	—	—	—	0.6	0.6	0.6
712105		FRONT BRAKE MASTER CYLINDER ASSEMBLY	—	—	—	—	0.4	0.4	0.4
712110		FRONT BRAKE LINE - UPPER	—	—	—	—	0.4	0.4	0.4

Operation Number	Detail Code	Description	Z 50R	XR 80R	XR 100R	XR 200R	XR 250R	XR 350R	XR 600R
810100		HANDLEBAR ASSEMBLY	0.4	0.5	0.5	0.5	0.5	0.4	0.4
810110		HANDLEBAR HOLDER(S)	—	0.2	0.2	0.1	0.1	0.1	0.1
810115		HAND LEVER BRACKET (EACH)	0.2	0.2	0.2	0.1	0.1	0.1	0.1
810125		HAND LEVER (BRAKE OR CLUTCH) (EACH)	0.1	0.1	0.1	0.1	0.1	0.1	0.1
810130		HAND LEVER COVER	—	0.1	0.1	0.1	0.1	0.1	0.1
810135		HAND LEVER GUARD(S)	—	—	—	0.1	0.1	0.1	0.1
810150		THROTTLE GRIP PIPE	0.2	0.2	0.2	0.4	0.4	0.4	0.4
810155		THROTTLE HOUSING	—	0.2	0.2	0.4	0.4	0.4	0.4
810165		REAR BRAKE PEDAL SHAFT	—	0.2	0.2	0.2	0.2	0.2	0.2
810160		REAR BRAKE PEDAL	0.2	0.2	0.2	0.2	0.2	0.2	0.2
810175		SHIFT LEVER	0.1	0.1	0.1	0.1	0.1	0.1	0.1
811100		THROTTLE CABEL(S)-ONE OR BOTH	0.2	0.4	0.4	0.4	0.4	0.4	0.4
811115		CLUTCH CABLE	—	0.2	0.2	0.2	0.2	0.2	0.2
811125		FRONT BRAKE CABLE(S)-ONE OR BOTH	0.1	0.1	0.1	0.1	—	—	—
811135		REAR BRAKE ROD	0.2	0.2	0.2	0.2	0.2	0.2	0.2
811150		DECOMPRESSION CABLE ENGINE	—	—	—	0.2	0.2	0.2	0.2
811155		DECOMPRESSION CABLE HANDLEBAR	—	—	—	—	0.2	0.2	0.2
811160		SPEEDOMETER CABLE	—	—	—	0.1	0.1	0.1	0.1
812100		SPEEDOMETER, TACHOMETER OR METER ASSEMBLY	—	—	—	0.2	0.2	0.2	0.2

812100		SPEEDOMETER, TACHOMETER OR METER ASSEMBLY	—	—	—	0.2	0.2	0.2	0.2
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PRICE CONVERSION TABLE

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Suggested Time (Hrs.)	LABOR RATE PER HOUR						
	\$3.50	\$4.00	\$4.50	\$5.00	\$5.50	\$6.00	\$6.50
0.1	0.35	0.40	0.45	0.50	0.55	0.60	0.65
0.2	0.70	0.80	0.90	1.00	1.10	1.20	1.30
0.3	1.05	1.20	1.35	1.50	1.65	1.80	1.95
0.4	1.40	1.60	1.80	2.00	2.20	2.40	2.60
0.5	1.75	2.00	2.25	2.50	2.75	3.00	3.25
0.6	2.10	2.40	2.70	3.00	3.30	3.60	3.90
0.7	2.45	2.80	3.15	3.50	3.85	4.20	4.55
0.8	2.80	3.20	3.60	4.00	4.40	4.80	5.20
0.9	3.15	3.60	4.05	4.50	4.95	5.40	5.85
1.0	3.50	4.00	4.50	5.00	5.50	6.00	6.50
2.0	7.00	8.00	9.00	10.00	11.00	12.00	13.00
3.0	10.50	12.00	13.50	15.00	16.50	18.00	19.50
4.0	14.00	16.00	18.00	20.00	22.00	24.00	26.00
5.0	17.50	20.00	22.50	25.00	27.50	30.00	32.50
6.0	21.00	24.00	27.00	30.00	33.00	36.00	39.00
7.0	24.50	28.00	31.50	35.00	38.50	42.00	45.50
8.0	28.00	32.00	36.00	40.00	44.00	48.00	52.00
9.0	31.50	36.00	40.50	45.00	49.50	54.00	58.50
10.0	35.00	40.00	45.00	50.00	55.00	60.00	65.00
20.0	70.00	80.00	90.00	100.00	110.00	120.00	130.00
30.0	105.00	120.00	135.00	150.00	165.00	180.00	195.00
40.0	140.00	160.00	180.00	200.00	220.00	240.00	260.00
50.0	175.00	200.00	225.00	250.00	275.00	300.00	325.00
60.0	210.00	240.00	270.00	300.00	330.00	360.00	390.00
70.0	245.00	280.00	315.00	350.00	385.00	420.00	455.00
80.0	280.00	320.00	360.00	400.00	440.00	480.00	520.00
90.0	315.00	360.00	405.00	450.00	495.00	540.00	585.00
100.0	350.00	400.00	450.00	500.00	550.00	600.00	650.00

Suggested Time (Hrs.)	LABOR RATE PER HOUR						
	\$7.00	\$7.50	\$8.00	\$8.50	\$9.00	\$9.50	\$10.00
0.1	0.70	0.75	0.80	0.85	0.90	0.95	1.00
0.2	1.40	1.50	1.60	1.70	1.80	1.90	2.00
0.3	2.10	2.25	2.40	2.55	2.70	2.85	3.00

0.2	1.40	1.50	1.60	1.70	1.80	1.90	2.00
0.3	2.10	2.25	2.40	2.55	2.70	2.85	3.00
0.4	2.80	3.00	3.20	3.40	3.60	3.80	4.00
0.5	3.50	3.75	4.00	4.25	4.50	4.75	5.00
0.6	4.20	4.50	4.80	5.10	5.40	5.70	6.00
0.7	4.90	5.25	5.60	5.95	6.30	6.65	7.00
0.8	5.60	6.00	6.40	6.80	7.20	7.60	8.00
0.9	6.30	6.75	7.20	7.65	8.10	8.55	9.00
1.0	7.00	7.50	8.00	8.50	9.00	9.50	10.00
2.0	14.00	15.00	16.00	17.00	18.00	19.00	20.00
3.0	21.00	22.50	24.00	25.50	27.00	28.50	30.00
4.0	28.00	30.00	32.00	34.00	36.00	38.00	40.00
5.0	35.00	37.50	40.00	42.50	45.00	47.50	50.00
6.0	42.00	45.00	48.00	51.00	54.00	57.00	60.00
7.0	49.00	52.50	56.00	59.50	63.00	66.50	70.00
8.0	56.00	60.00	64.00	68.00	72.00	76.00	80.00
9.0	63.00	67.50	72.00	76.50	81.00	85.50	90.00
10.0	70.00	75.00	80.00	85.00	90.00	95.00	100.00
20.0	140.00	150.00	160.00	170.00	180.00	190.00	200.00
30.0	210.00	225.00	240.00	255.00	270.00	285.00	300.00
40.0	280.00	300.00	320.00	340.00	360.00	380.00	400.00
50.0	350.00	375.00	400.00	425.00	450.00	475.00	500.00
60.0	420.00	450.00	480.00	510.00	540.00	570.00	600.00
70.0	490.00	525.00	560.00	595.00	630.00	665.00	700.00
80.0	560.00	600.00	640.00	680.00	720.00	760.00	800.00
90.0	630.00	675.00	720.00	765.00	810.00	855.00	900.00
100.0	700.00	750.00	800.00	850.00	900.00	950.00	1000.00